

SPLIT

GREEN

Dart Aerospace Ltd.

Date: Monday, 8/21/2006 2:13:03 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TOW RING
 Job Number : 28267
 Estimate Number : 10396
 P.O. Number : N/A
 This Issue : 8/21/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 27924
 Part Number : D2968041
 Drawing Number : D2968
 Project Number : N/A
 Drawing Revision : B1
 Material : N/A
 Due Date : 9/20/2006 Qty: 40 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 28267A STEM



Comment: Sub-Component STEM
 D2968-1 B 28267A

AS 06/09/19 (40)

2.0 28267B RING



Comment: Sub-Component RING
 D2968-5 B 27924B

AS 06/09/19 (40)

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2968-1 & D2968-5 as per Dwg D2968 & QSI 004 using 4130 welding rod Identify as D2968-041

Batch: M15684

AS 06/09/19 (40)

4.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

PD 06-09-19 (40)

5.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 2089 C Lde109/20 (40)

Description: D2968-041 to heat treat to ultimate tensile strength

125ksi as per Dwg D2968

Conformity sheet required

Issue P/O: 2090

C Lde109/20 (40)

Cad Plate per QQ-P-416F Class I Type II

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 28267

Part Number: D2968041

Job Number:



Seq. #:

Machine Or Operation:

Description:

Conformity sheet required

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

0306/10/17 (40)

7.0

QCS

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CAD PLATE

June 20 0306/10/17

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DO NOT POWDER COAT THREADS

y/a.m. (4) 06/11/14 x 4

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

0306/11/16 (4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57480

0306/11/16 (4)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(4) 0306/11/16

Job Completion



0306/11/16

Dart Aerospace LTD
Client / Customer

Votre # de commande / Your purchase order #

D2968-041
de la pièce / part #101082
Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector <u>Renault</u>	Date, équipe / Date, shift <u>10 OCT 2006</u>
Placage / Plating <u>Q98416 F Class 1 Type II</u>	
Quantité totale / Total quantity <u>40</u>	Quantité inspectée / Inspected quantity <u>40</u>
Adhésion / Adhesion <u>bonne</u>	
Épaisseur / Thickness L.C.D. H.C.D. Moy. / aver. <u>0.0005</u>	
Coulisses, taches / Leach, spots <u>Non</u>	Rugosité / Roughness <u>Non</u>
Quantité approuvée / Approved quantity <u>40</u>	Quantité rejetée / Rejected quantity <u> </u>

Commentaires / Comments

Noûs certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of**MANCO**
DOMPLEX



RELEASE NOTE

GST No.: R105468102

OAK 79593-1

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☐ QUEBEC DIVISION
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CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

10/02/2006

MM/DD/YYYY

PAGE: 1

1DAR01
BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: MANCO COMPLEX
4660 HICKMORE
ST. LAURENT, QUEBEC

K6A 1K7

H4T 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
10/02/2006	PUROLATOR 7684382	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO00002089		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2968-041	TOW RING	EA	40	40	
Process Specifications: Procedure: 4047 HEAT TREATED TO 125 KSI MIN. ✓ HRC 27-32.5 MATERIAL: 4130 B28267					
<div style="border: 1px solid black; padding: 5px; display: inline-block;"> 100% HARDNESS TESTED 40 PCS. 31/32 HRC </div> <div style="border: 1px solid black; border-radius: 50%; padding: 5px; display: inline-block; margin-top: 10px;"> VAL. O. TH. 25 Q.C. </div>					

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Diana Freeman
Authorized Q.C. Inspector



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT

TURNING COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS

HEAT TREATING